

Work Order ID 92955-2

November-12-12 1:36:39 PM

SPLIT-2.  
Change habour to  
RD 4397.

\*92955\*

Page 1

Item ID: D4635-1

Revision ID:

Item Name: Fwd Ceiling Panel, LH

Start Date: 12/11/2012 Start Qty: 2.00

Required Date: 12/12/2012 Req'd Qty: 2.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: M L S Date: 12-11-12 Tooling:

QC: Date: SPC (Y/N):

Run Start \*NR1\*

Stop \*NR2\*

Work Order ID	Description	Run hours	Part Code	Accept Qty	Reject Qty	Reject Number	Sp. Stamp
---------------	-------------	-----------	-----------	------------	------------	---------------	-----------

Draw Nbr

Revision Nbr

D4635

100

\*100\*

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

Cut Blanks

0.00

0.00

x2

07

12/12/04

105

\*105\*

HandThermo

Hand Finishing Thermoforming

Dry Material

Memo

Dry Sheet as per QSI022 KYDEX

Temp: 150° F

Time IN:

7:00 pm

12/12/03

Time OUT:

7:00 am

12/12/04

x2

OK

12/12/04

# Work Order ID 92955

November-12-12 1:36:39 PM

**\*92955\***

Page 2

Item ID: D4635-1

Accept

**\*N9000040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Fwd Ceiling Panel, LH

Start Date: 12/11/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00

**\*110\***

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4635-1 and Folio FTA147

Dwg. Rev. A

Folio Rev. A

Visually inspect for proper formation and texture

x2

12/12/04

130

0.00

**\*130\***

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

X1

BB

13/03/21

140

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*140\***

QC

Memo

0.00

Quality Control

N

BB 13/03/21



# Work Order ID 92955

November-12-12 1:36:39 PM

\*92955\*

Page 3

Item ID: D4635-1

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Fwd Ceiling Panel, LH

Stop

\*NS2\*

Start Date: 12/11/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

DAS  
16  
13/04/10

160

Packaging

0.00

\*160\*

Packaging

Memo

0.00

Packaging

Med Fab  
B98236

13/04/10

170

QC21- Final Inspection - Work Order Release

0.00

\*170\*

QC

Memo

0.00

Quality Control

13/4/10

13-0410

# Picklist Print

November-12-12 1:36:43 PM

Page 1

Work Order ID: 92955

\*92955\*

Parent Item: D4635-1

\*D4635-1\*

Parent Item Name: Fwd Ceiling Panel, LH

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,028.362	13.36	29.68889			

\*MKYD6185S 080-P3-62015\*

6185 KYDEX .080"

\*\*

Location

Loc Qty

Loc Code

therm

1028.362377

116576

14.148377

101755

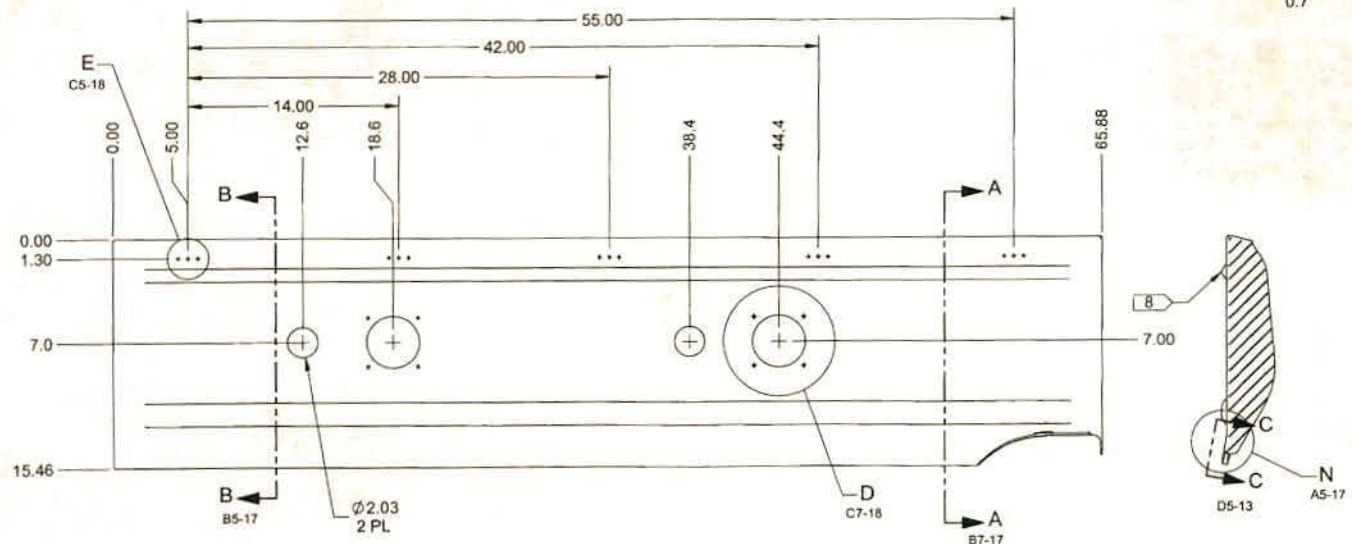
1014214

29.6959

13.36

OK  
12/12/10





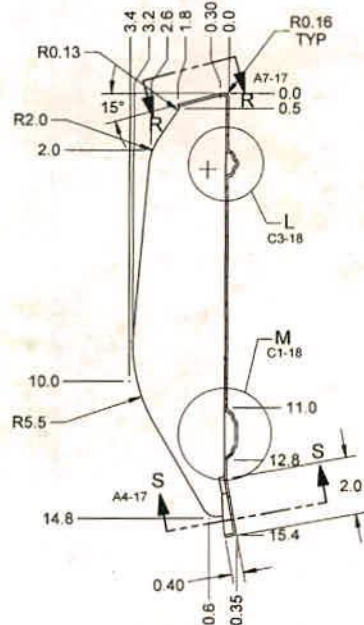
**NOTES:**

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.29 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-1 PER TOOL DT9839
- 10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL  
MIN. THICKNESS AFTER FORMING:  
SHADED AREA = 0.040  
RIDGES/EDGES = 0.060  
ELSEWHERE = 0.070

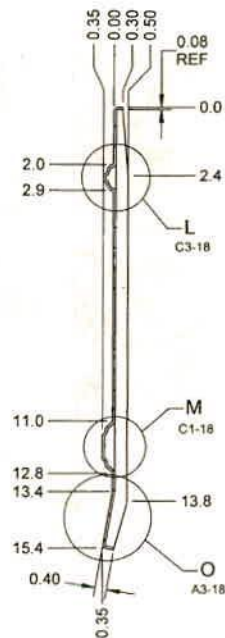
**D4635-1 LH, FWD CEILING PANEL**

13 2013-01-30  
mp

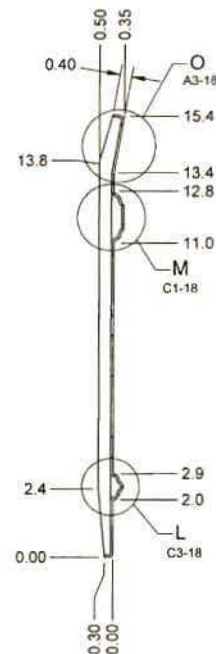
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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4635</b>	SHEET 13 OF 18
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>OUTBOARD CEILING PANELS</b>	NTS
DATE	12.11.30	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMING OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



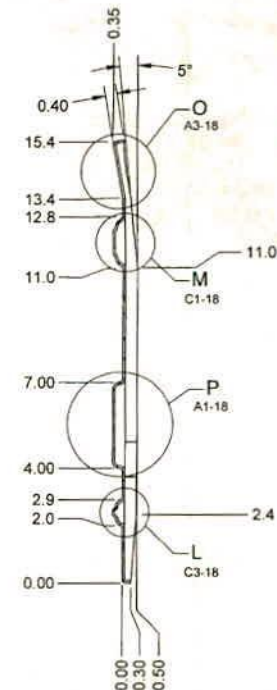
**SECTION A-A**  
SECTION A-A' OPPOSITE  
SCALE 2X



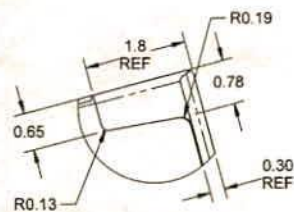
**SECTION B-B**  
SCALE 2X



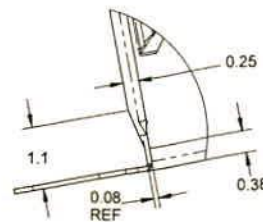
**SECTION G-G**  
SCALE 2X



**SECTION K-K**  
SCALE 2X



**AUXILIARY VIEW R-R**  
SECTION R-R' OPPOSITE  
SCALE 2X

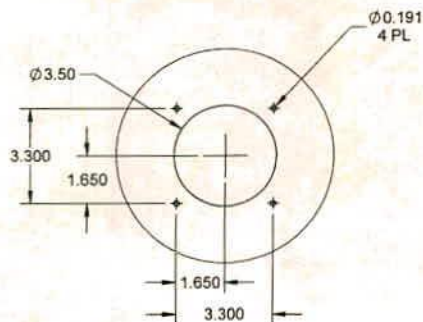


**AUXILIARY VIEW S-S**  
SECTION S-S' OPPOSITE  
SCALE 2X

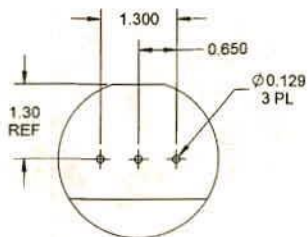
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2013-01-30

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CHECKED	RF	DRAWING NO.	REV. B
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APPROVED	RF	TITLE	SCALE
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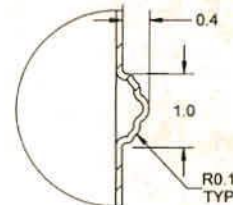




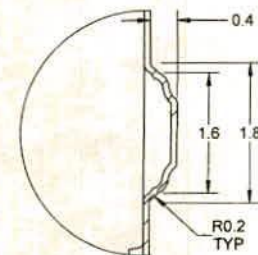
**DETAIL D**  
SCALE 2X  
B4-13  
B3-14  
B5-15  
B5-16



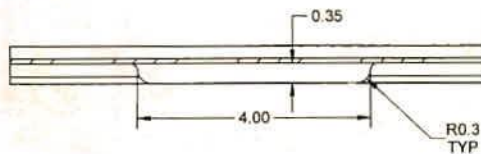
**DETAIL E**  
SCALE 4X  
C7-13  
B6-14  
C6-15  
B5-16



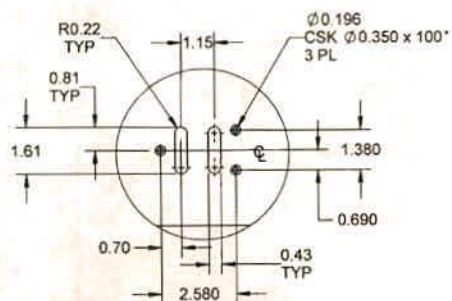
**DETAIL L**  
SCALE 1.5X  
B2-17  
B4-17  
C5-17  
C7-17



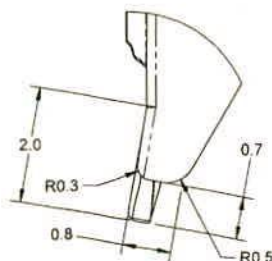
**DETAIL M**  
SCALE 1.5X  
C2-17  
C3-17  
C5-17  
C7-17



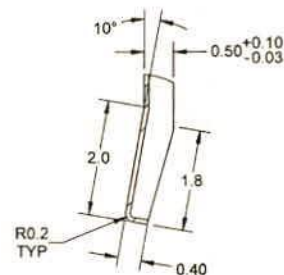
**SECTION I-I**  
SCALE 4X  
B5-16



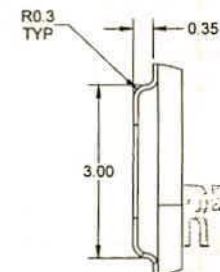
**DETAIL Q**  
SCALE 2X  
C5-16



**DETAIL N**  
SCALE 2X  
B2-13



**DETAIL O**  
SCALE 2X  
D2-17  
D3-17  
B5-17



**DETAIL P**  
SCALE 4X  
C2-17

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4635</b>	SHEET 18 OF 18
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>OUTBOARD CEILING PANELS</b>	NTS
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RELEASED  
2013-01-30  
WP

DART AEROSPACE LTD		Work Order: 92955
Description: 139 LH FWD Ceiling Panel		Part Number: D4635-1
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <i>HL</i>	Date: 13/07/04
------------------------	----------------

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
65.88	.030	65.75	✓	✓	TH -05	
15.46	.030	15.46	✓		"	
1.30	.030	1.35			"	
5.00	.030	4.95			"	
14.00	.030	14.00			"	
28.00	.030	28.00			"	
42.00	.030	42.00			"	
55.00	.030	55.00			"	
7.00	.030	7.00			"	
12.6	.030	12.6			"	
18.6	.030	18.6			"	
38.4	.030	38.4			TH -05	

Measured by: <i>JB</i>	Date: 13/03/21
Audited by: <i>S1364/05</i>	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

*10-04-14*



DART AEROSPACE LTD		Work Order: 92955
Description: 139 LH FWD CEILING PANEL		Part Number: D4635-1
Inspection Dwg: 4635	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	/			
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: JB	Date: 13/03/21
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#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
44.4	.030	44.4	/		TH-03	
2.03	.030	2.01	/		DL-02	
3.50	.030	3.51	/		DL-02	
2.03	.030	2.01	/		DL-02	
3.50	.030	3.52	/		DL-02	
.30	.030	.33	/		DL-02	
.40	.030	.38	/	✓	DL-02	
.50	.030	.55	/		DL-02	
2.4	.100	2.375	/		TH-03	
13.8	.100	13.825	/		TH-03	
.040	Min	.046	/		DL-02	
.060	Min	.052	/	✓	DL-02	
.070	Min	.064	/	✓	DL-02	

Measured by: JB	Date: 13.03/21
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Audited by: 813104105	Date:
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



DART AEROSPACE LTD

Work Order: 72955

Description: 139 LH FWD CEILING PANEL

Part Number: 4635-1

Inspection Dwg: 4635 Rev: B

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL

Date: 12/12/04

## TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.8	100	1.41			DL 02	See Letter
.78	030	.778	✓		DL 02	
.65	030	.658	✓		DL 02	

Measured by: BB

Date: 13/03/24

Audited by: S. 12/04/05

Date:

Preliminary Approval:

Date:

Rev	Date	Change
B	10.04.14	Added preliminary approval

Revised by	Approved
KJ	

AD 10 05/10/05



## Daryl Leger

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**From:** Roberto Fuentes  
**Sent:** Thursday, April 04, 2013 9:53 AM  
**To:** Daryl Leger; Harvey Siemens; David Shepherd; Mike Petsche; Eric Downing; Patrick Smith; Linda Lacelle  
**Subject:** Deviations for A139 drawings panels

Hi Daryl,

All this changing will be recorded as deviation for this first production and change the drawing after we get the comments from ERA from the first installation.

In response to your e-mail I summarize the following:

- 1) It is acceptable to change 1.8" to 1.4" dimensions for D4635-1/-2 Rev. B showing in Section A-A and Auxiliary View R-R.
- 2) It is acceptable change overall length of D4635-1/-2 from 65.88" to 65.75".
- 3) It is acceptable to have flange height on back side for D4635-1/-2/-3/-4 change from 0.40" to 0.35".
- 4) It is acceptable to have on D4635-1/-2/-3/-4 minimum thickness after thermo forming:  
Ridges/edges = 0.050"  
Elsewhere = 0.060"
- 5) This is applicable to note 8) of D4634 & D4635 drawings. Apply a bead (0.20" to 0.30 wide) of Devcon plastic welder II (0.25 inside of both edges of part) to bond ..... Wait for 2 to 4 hours for functional cure.
- 6) It is acceptable to identify with p/n & batch # at note 6) for D4634-141/-143/-145 & D4635-141/-142/-143/-144
- 7) This is applicable to note 10) of D4634-141/-143/-145. Locate D4647-3 angle using groove to align with ..... (Refer to Detail 'S')
- 8) This is applicable to note 11) of D4634-141/-143/-145. Transfer  $\varnothing 0.206$ " holes from D4634-# panel to D4694-# channels.

Roberto